

Date: Tuesday, 25/11/2008 2:04:56 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 43726					
Estimate Number	: 10671					
P.O. Number	:			Part Number	: D29701	
This Issue	: 25/11/2008		S.O. No.	: D2970 REV A		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 33220			Drawing Revision	: A	
Written By	:			Material	:	
Checked & Approved By	: <u>MF 08-11-25</u>			Due Date	: 02/12/2008	
Comment	: Est: B 01.06.07 Added Material and Tool number SM/EC			Qty:	20	Um: Each
	Est Rev:C Now on Waterjet 07-06-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S20GA	1010/1025 SHEET
		Comment: Qty.: 0.3833 sf(s)/Unit Total : 7.6650 sf(s) 1010/1025/A21/6aA SHEET 20 GauGE .040" Batch: <u>109089</u> <u>RB 8-11-26</u> <u>108075</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2970 Dwg Rev: <u>A</u> <u>RB 8-11-26</u> Prog Rev: <u>A</u>
		2-Deburr if necessary <u>RB 8-11-26</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>RB 8-11-26</u>
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <u>S08/4626</u> <u>RB 8-11-26</u> <u>counter</u>
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Deburr and form on brake using DT8178 and DT8261 as per Dwg D2970 <u>RB 8-11-26</u> <u>26</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPLATE
Job Number: 43726		Part Number: D29701
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		S 08/11/26 426 counter
7.0	POWDER COATING	POWDER COATING  M 109 648  (Q6x)
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		
START TIME: 2-10 OVEN TEMPERATURE: 320° FINISH TIME: 2-40		MF 08/11/26
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		FX 08/11/26 (26)
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FP-16		FX 08/11/26 (26)
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		08/11/27 (27)
Job Completion 		MF 08-11-26

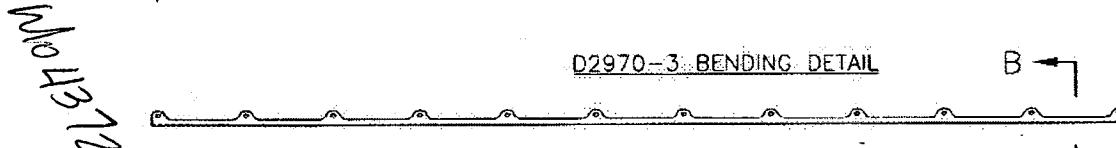
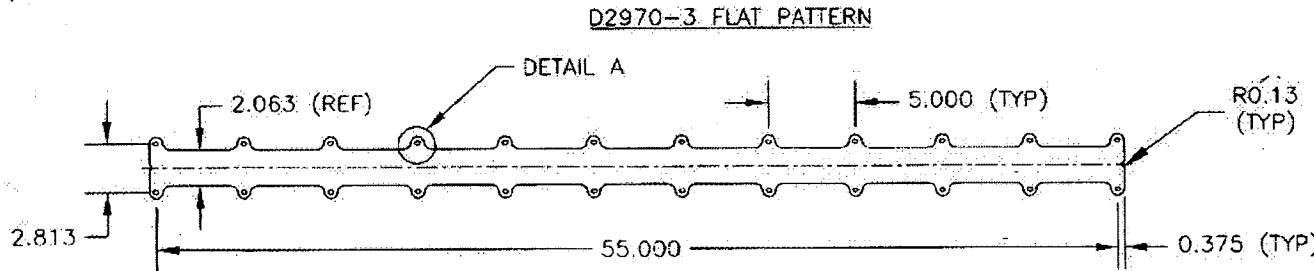
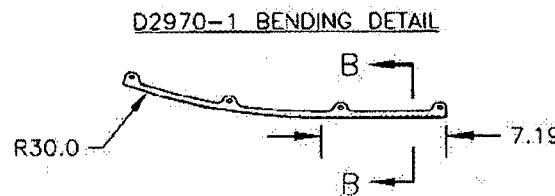
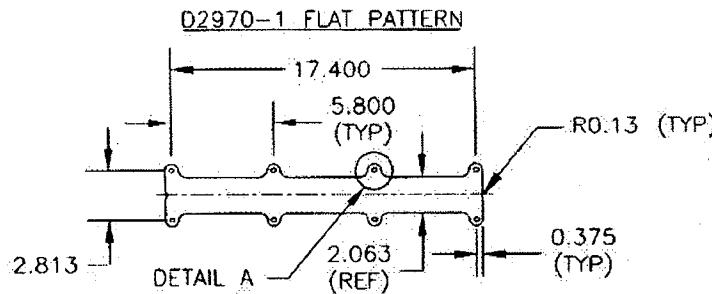
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

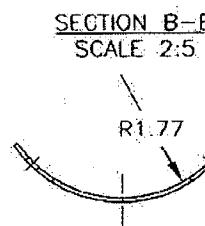
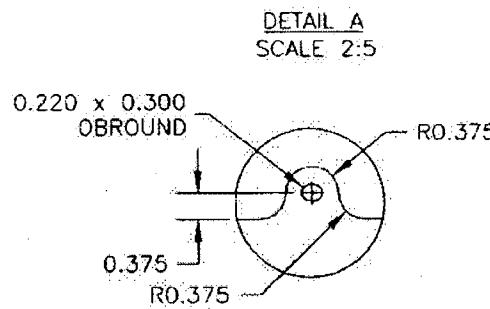
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/M/B/M
BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005-4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

REFERENCE ONLY



DART

QA COPY

DESIGN P#	DRAWN BY RF	DART AEROSPACE USA, INC.	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D2970	REV. A
DATE 00.03.10	TITLE WEARPLATE	SHEET 1 OF 1	
A	00.03.10	NEW ISSUE	110

RELEASED
04.5.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43726
Description: WEAR PLATE	Part Number:	D2970-1
Inspection Dwg: D2970-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

Measured by: HB	Audited by: <u> </u>	Prototype Approval: 1 / <u> </u>
Date: 8-11-26	Date: 08/14/26	Date: <u> </u> / <u> </u>

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	